

Date: Tuesday, 4/17/2007 3:56:11 PM  
 User: Kim Johnston

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: STIFFENER
Job Number	: 31920		
Estimate Number	: 10481		
P.O. Number	: <u>N/A</u>	Part Number	: D2353
This Issue	: 4/17/2007 S.O. No. : <u>N/A</u>	Drawing Number	: D2353 REV.C
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: <u>N/A</u> Type : SMALL /MED FAB	Drawing Revision	: C
Previous Run	: 29145	Material	: <u>N/A</u>
Written By	:	Due Date	: 5/2/2007
Checked & Approved By	: <u>Handwritten Signature</u>	Qty:	10 Um: Each
Comment	Est Rev: A Removed from 9 Digit 05-11-10 EC Est: B 06.11.15 waterjet EC est: c 06.12.07 ecn 836 ec		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M2024T3S050	2024-T3 .050 sheet
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Comment: Qty.: 0.1536 sf(s)/Unit Total : 1.5362 sf(s)  
 Material: 2024-T3 .050 sheet  
 Aluminum (QQ-A-250/5)  
 Batch: H103321

SAD 07/05/18 10

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET  
 1-Cut as per Dwg D2353  
 Dwg Rev: C  
 Prog Rev: C

2-Deburr if necessary

SAD 07/05/18 10  
MF 07-05-22

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SAD 07/05/18 10

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

BG 07-05-18 10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: SR Date: 07/03/28  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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## Process Sheet

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Drawing Name: STIFFENER

Job Number: 31920

Part Number: D2353

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

Bend per Dwg D2353

SBS 07/05/22 (10)

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

2005-23 (10)

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

Sed/BK 07/05/24 (10)

8.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

M102316

ed 07-05-25 (10)

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

Pc 7/5/28 10

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

identified on SAC PA

\* \*\*\*\*\*Identify with white fine point permanent marker and Stock\*\*\*\*\*  
Location: 270

NA

7/5/28

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

(10)  
R 07/05/28

Job Completion



U 7/5/28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

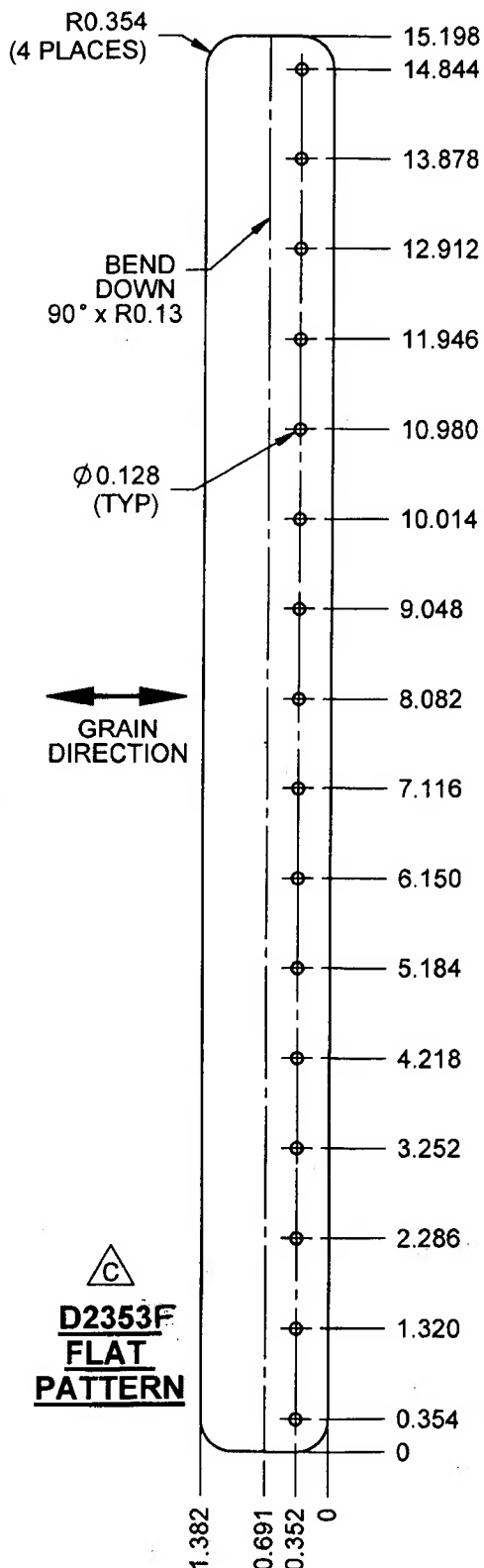
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

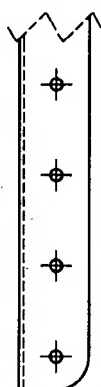
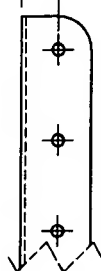


**DART**

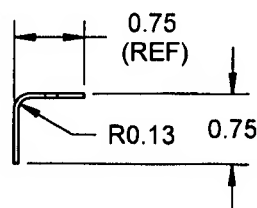
DESIGN BW	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED LE	APPROVED [Signature]	DRAWING NO. D2353	REV. C SHEET 1 OF 1
DATE 06.11.13	TITLE STIFFENER SCALE 1:2		
REV	DATE	DESCRIPTION	
B	95.02.23	ADD TEXT	
C	06.11.13	ADD FLAT PATTERN; ADD NOTES; UPDATE DWG	



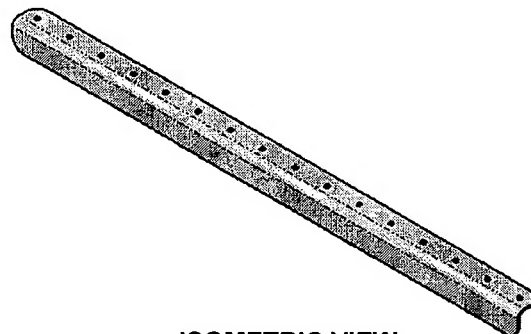
0.40  
(REF)

**NOTES:**

- 1) MATERIAL: ALUMINUM 2024-T3 SHEET, 0.050 THICK  
PER QQ-A-250/4 OR AMS 4037  
(REF DART SPEC M2024T4S.050)
- 2) FINISH: CHEMICAL CONVERSION COAT  
PER DART QSI 005 4.1  
POWDER COAT BLACK SANDTEX (4.3.5.7)  
PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS  
OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D2353" USING A WHITE  
FINE POINT PERMANENT INK MARKER
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS  
OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX



**D2353  
BEND DETAIL**



**ISOMETRIC VIEW  
SCALE 1:4**

SHOP COPY  
RETURN TO

RELEASED  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT

WITHOUT NOTICE  
WORK ORDER  
NO. 31920

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